

Date: Friday, 11/18/2005 5:29:30 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 24876		
Estimate Number	: 10333		
P.O. Number	: NIA	Part Number	: D2530
This Issue	: 11/18/2005 S.O. No. : NIA	Drawing Number	: D2530 REV B
Prsht Rev.	: NC	Project Number	: NIA
First Issue	: NIA Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 24111	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/20/2005
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	20 Um: Each
Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	24876A	LOCK PLATE
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Comment: Sub-Component LOCK PLATE

2.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4809 f(s)/Unit Total : 9.6180 f(s)
 Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)
 Batch: M18983

SAD 12/22/05 F20

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

SAD 12/22/05 F20

4.0	D2534	Lock Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	<u>B-24876A</u>

LE. 06-01-19 = 20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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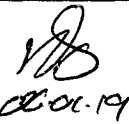
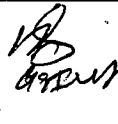
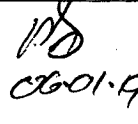
Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

LE. 06-01-19 = 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.1.19	5.0	welded handle together did not sit flush at both ends so it was twisted to sit better but but was twisted to much and was no good		made a new part to finish the order	06.1.19	 06.01.19		 06.01.19

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 24876

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/01/20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

ml 06 01 22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 06/01/23 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

CL 06/01/23 20

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.0 06/01/23 (20)

06/01/23 (20)

Job Completion



WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	: 0024876	Department Code:	
Project Name	: D2530	Burden Flags	: NNNNNNNN
Project For	: WK549	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2530	Invoice Number	:
Description	: Handle Weldment	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-18-05		
Est Finish Date	: 12-05-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

CONTROLLED COPY

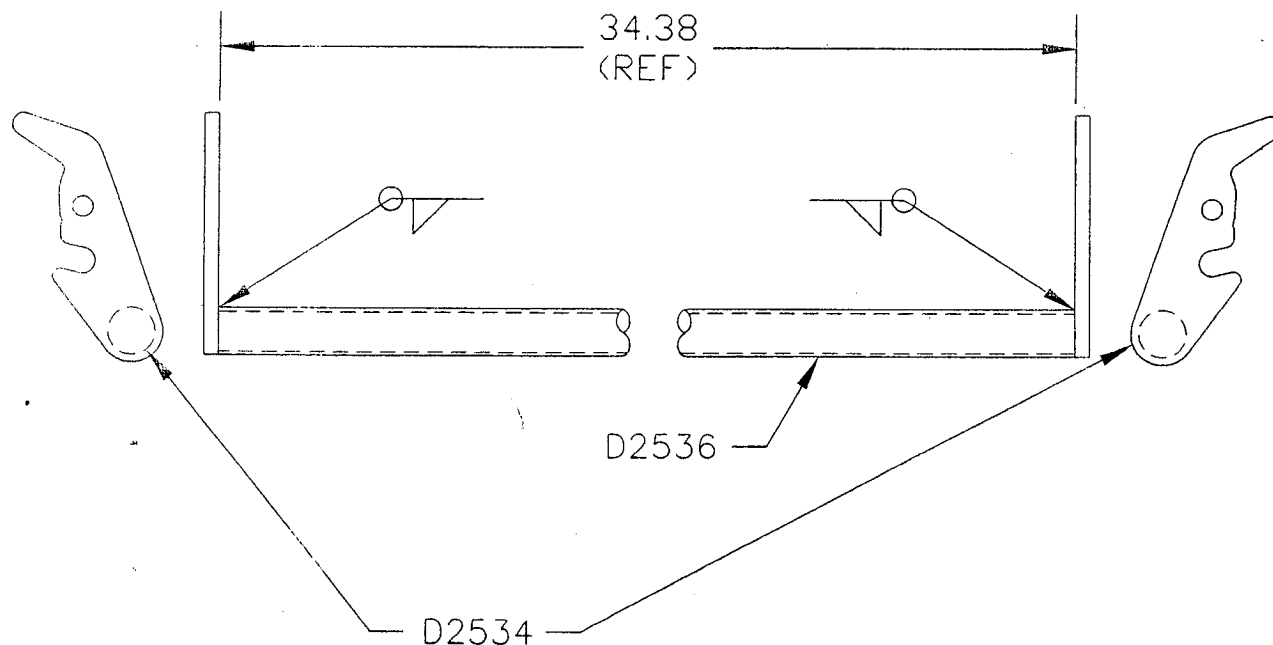


DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED
04.12.16

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED